Work Orde Friday, October				*126	3198*			M	ording pl	asl	Page 1
Revision ID:	D3575-5 Cargo Floor P	rotector		Accept	*N900	040	100)* s	Setup Sta	171	S1* S2*
Required Date:	10/31/2014 11/4/2014	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:						
Reference: Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		eate:	_	R	Run Star	" !\	R1* R2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr								-	
D3575	Rev	A									
*100 *100* Waterjet FLOW CNC Waterje	et	FLOW WATER JET Memo 1-Cut as pe Deburr if ne		0.00 0.00 Rev: <u>A</u> Prog Rev: <u>A</u>	2-					De 1	7/11/01
110		QC2- Inspect parts off n	nachine FAI/FAIB	0.00				(2			//
110 QC Quality Control	·	Memo		0.00						De 14	<u> </u>
120		QC8- Inspect parts - sec	ond check	0.00							
120 QC		Memo		0.00				_ €	14.11	.03	DAS ————————————————————————————————————

Quality Control

DQA:			Date:			WORK ORDER NON	c	ONEO	DNAANCE / II	IDDATE			DART
QA Closed:			Date:			WORK ORDER NON-	-((JIVFUI	RIVIAINCE / U		Vork Order u	odate only	AEROSPACE
Mark Orde	or:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Work Orde	er. —					Rework	1		Child Author	Cun cotult o [7	Water Jet	
Part N	u.					Scrap	Machining		Skid-tube	Crosstube Small Fab	- Dra	<u> </u>	Engineering Quality
Parti	NO. —					Use-as-is			noforming	Finishing		d. Eng. Coor. re/Packaging	Other
NCR I	No.					Suspected Unapproved		mem	Large Fab	Composite	-	Supplier	
NCK	'					Juspected Onapproved	zarge rasesmposite					3uppliet _	
Root					Desci	ription of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Design						,							
Doc/Data													
Equip/Tooling											Į		
Handling/Pre													
Material											1		
Operator						1							
Offset/Setup													
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	В	ending				Bend		Folio/P	rogram	L	Outside Dim	ensions	Pressure/Forced
		entre No	t Concer	ntric	_	BOM/Route		Grain		L	Over/Under	tolerance	Set-up
	c	racks				Broken/Damage/Defect		Hardwa	re		Part Incorred	ct _	Temperature/Cure
	c	rimp/Kin	k/Ripple	/Wave		Burrs		Inspecti	on Incomplete/U	inqualified	Part Lost/Mi	ssing	Weld
		uffs				Contamination		Instructi	ions Incomplete/	Unclear	Part Moved		Wrong Stock Pulled
	c	rushing				Countersink		Misalig	ned/off center		Positioned V	Vrong	
	Шн	eat Trea	t			Cut Too Short		Mislabe	led		Power Loss/	Surge	Other
	∐]1r	rspection	Strip in	Tube		Drawing		Misread	I				
		1arks/Ch	atter			Drill Holes		Off-set					
	Шт	urning Se	equence			Finish	Out of Calibration						
	Wave/Twist in Tube				Fit/Function		Out of S	equence					

Work Orde Friday, October				*126198*										
Item ID:	D3575-5			Accept	*N900	040	100)*	Setup	Start	*N	S1*		
Revision ID:										Stop	4. N. I.	00+		
Item Name:	Cargo Floor P	rotector								отор	*I/J;	S2*		
Start Date:	10/31/2014	Start Qty: 1.00	*1*		Cust Item 1	D:								
Required Date:	11/4/2014	Req'd Qty: 1.00	*1*		Customer:									
Reference:			•											
Approvals:	Process Pla	nn:	Date:	Tooling:	D	ate:	_		Run	Start	*N	R1*		
	QC:		Date:	_ SPC (Y/N):	D:	ate:				Stop	*N	IR2*		
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Reje Qty		Reject Number	Insp. Stamp		
130				0.00										
120 Small Fab		Small Fab Memo Deburr if he	ccessary.	0.00									_	
140		QC5- Inspect part compl	leteness to step on W/O	0.00					ر در					
1 <i>4</i> 0									4	•				
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150

Identify as per dwg & Stock Location:

0.00

DAS 96 9-69

150 Packaging

Packaging

Quality Control

Memo

0.00

666126193

NOV 0 4 2014

DQA:			Date:			WORK ODDED NON	<u></u>	ANE O	DNANICE / I	LIDDATE			DART
QA Closed:			Date:			WORK ORDER NON	-C(JIVFUI	RIVIAINCE / C		Work Order u	pdate only	AEROSPACE
NAV a vide O vid a						DISPOSITION				AGAINST I	DEPARTMENT	/PROCESS	
Work Orde	er:	 				D	1		and the limit	С Г	_	14 45455545	7
Part N	ام					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	- Dro	Water Jet od. Eng. Coor.	Engineering Quality
raitiv	··· —			·		Use-as-is			- ⊢	Finishing	-	re/Packaging	Other
NCR N	lo					Suspected Unapproved					Supplier	J	
Root		-		<u> </u>	Dosc	ription of work order update]	Initial	Λ	ction	Sign &	1	
Cause		Date	Step	Qty	Desci	or non-conformance	1	iief Eng		cription	Date	Verification	OCInspector
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Doc/Data	-												
Equip/Tooling													
Handling/Pre	\dashv												
Material	-												
Operator	\dashv												
Offset/Setup	\dashv												
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	В	ending				Bend		Folio/P	rogram		Outside Dim	nensions	Pressure/Forced
	c	entre No	t Concer	ntric		BOM/Route		Grain		Ĺ	Over/Under	tolerance	Set-up
	c	racks				Broken/Damage/Defect		Hardwa	re		Part Incorre	ct	Temperature/Cure
	c	rimp/Kin	k/Ripple	/₩ave		Burrs		Inspecti	on Incomplete/l	Jnqualified	Part Lost/M	issing	Weld
		uffs				Contamination		1	ions Incomplete,	·	Part Moved		Wrong Stock Pulled
	—	rushing				Countersink		1	ned/off center	· [Positioned V		_
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	Wave/Twist in Tube			e		Fit/Function		Out of S	equence				

Work Order	ID	126198
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126198

Page 3

Friday, October 31, 2014 12:43:28 PM Accept *N900040100* Item ID: D3575-5 Setup Start **Revision ID:** Stop **Item Name:** Cargo Floor Protector *1* 10/31/2014 Start Qty: 1.00 **Cust Item ID: Start Date: Req'd Qty:** 1.00 **Required Date:** 11/4/2014 *1* **Customer:** Reference: Start Run **Tooling:** Date: Date:_ Approvals: Process Plan: Stop SPC (Y/N): Date: QC: Date: Reject Tool ID Tool# Plan Reject Insp. Operation Set Up/ Accept Sequence ID/ Code Qty Qty Number Stamp **Work Center ID** Description **Run Hours** 0.00 160 QC21- Final Inspection - Work Order Release *160* 0.00 Memo

Quality Control

M 4.11.04

DQA:		_ Date:										[™] ⊃ΔPT
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / UF		Vork Order uj	ndate only	AEROSPACE
QA Closed.		Date.					r		v	voik Oldel uş	date only	<u> </u>
Work Orde	er:				DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
					Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
				_	Use-as-is	1		noforming	Finishing		re/Packaging	Other
NCR N	lo				Suspected Unapproved	1		Large Fab	Composite		Supplier	
						_				_		
Root				Descr	ription of work order update	1	Initial	Acti		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	iption	Date	Verification	QC Inspector
Design					-							
Doc/Data											·	
Equip/Tooling												
Handling/Pre												
Material												
Operator						l						
Offset/Setup										ļ		
Process												
Supplier						1						
Training												
Transport												
Unapproved						<u> </u>						
						FAI	ULT CAT	TEGORY				
Landir	ng Gear				General]		Γ	7		-
}	Bending			\vdash	Bend	\vdash	1	rogram	<u> </u>	Outside Dim	⊢	Pressure/Forced
•		ot Concer	ntric		BOM/Route	┝	Grain			Over/Under	⊢	Set-up
}	Cracks		40.04	\mathbb{H}	Broken/Damage/Defect	<u> </u>	Hardwa			Part Incorred	⊢	Temperature/Cure
-		nk/Ripple	e/Wave		Burrs	<u> </u>	1	on Incomplete/Un	· -	Part Lost/Mi	ssing	Weld
-	Cuffs			\vdash	Contamination		1	ions Incomplete/U	nclear	Part Moved		Wrong Stock Pulled
-	Crushing				Countersink	\vdash	1 -	ned/off center	<u> </u>	Positioned W	_	ا ا
	Heat Trea		T t.	- ⊢	Cut Too Short		Mislabe			Power Loss/	Surge	Other
		n Strip in	rube		Drawing	_	Misread	1				
	Marks/Cl			\mathbb{H}	Drill Holes	-	Off-set	Salikanaki a				
		Sequence vist in Tub			Finish Fit/Function	\vdash	1	Calibration Sequence		· · · · · · · · · · · · · · · · · · ·		
	IVVaVE/IV	vist III TUL	JC		11 10 1 URCUUH		1041012	EUDELLE				

Picklist Print

Friday, October 31, 2014 12:43:27 PM

Work Order ID: 126198

126198

Parent Item:

D3575-5

D3575-5

Parent Item Name: Cargo Floor Protector

Start Date: 10/31/2014

Required Date: 11/4/2014

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev : A New Issue 07.07.23

verified by:JLM

Component Item ID/
Item Name

Replacement Mfg/ **Item ID**

Purch

Primary Bin Item Location

Last Location

Route Seq ID Unit of Qty on Measure Hand

10.666

Qty

Date **Issued**

Status

Page 1

MLEXS.125-F60029-04

sf

**

12

Issued

Qty

Purchased

No

100

5,139.021

Qty per Kit Total

MI FXS 125-F60029-04

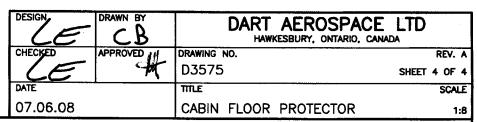
GE PLASTICS LEXAN SHEET

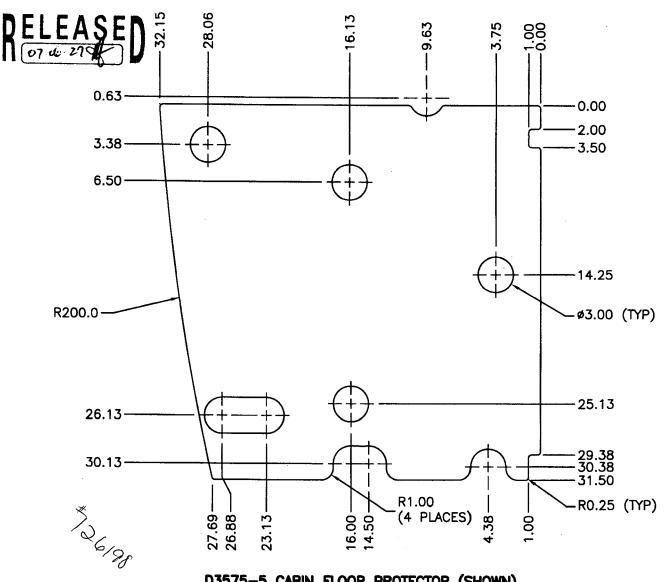
Location	1	Loc Oty	Loc Code
MAT019		2579.02178	
	124866	106	
	m126425	160.925	
	m127934	665	
	m128746	80.505	
	m129759	1566.59178	
SABIC		2560	
	m130209	2560	

DQA:	Date:											™ ⊃∧DŤ
					WORK ORDER NON-	-C(ONFO	RMANCE / L	JPDATE			AEROSPACE
QA Closed:		Date:							W	ork Order u	odate only	
Work Orde	ır.				DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Work Orac					Rework	1		Skid-tube	Crosstube	٦	Water Jet	Engineering
Part N	lo.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		Thermoforming Finishing				re/Packaging	Other
NCR N	lo				Suspected Unapproved		Large Fab Composite		Composite		Supplier	
Root				Desci	ription of work order update	ı	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling			1									
Handling/Pre			;									
Material												
Operator												
Offset/Setup		ļ										
Process	_											
Supplier	_											
Training								_				
Transport	_											
Unapproved						<u> </u>						
						FAI	ULT CAT	EGORY		 ,		
Landir	ng Gear				General		le-1:-75			7		7. /.
-	Bending				Bend BOM (Bounds	-	t	rogram	ļ	Outside Dim	 	Pressure/Forced
}	_	Not Conce	ntric	-	BOM/Route	_	Grain			Over/Under	-	Set-up
}	Cracks	اماد/۵:مماد	. /\4/	-	Broken/Damage/Defect	<u> </u>	Hardwa			Part Incorred		Temperature/Cure
}		ink/Ripple	e/wave	-	Burrs	_	1	on Incomplete/U	· ·	Part Lost/Mi	ssing	Weld
}	Cuffs Crushin	,			Contamination Countersink	\vdash	ł	ions Incomplete/ ned/off center		Part Moved Positioned V	/rong	Wrong Stock Pulled
· }	Heat Tre	=			Cut Too Short	\vdash	Mislabe		<u> </u>	Power Loss/	· ·	Other
}		eat on Strip in	Tubo	-	Drawing	-	Misread		<u>L.</u>	Jrower Lossy.	L	Tomer
}	Marks/0	· .	Tube		Drill Holes	\vdash	Off-set	4				
}				-	Finish	Out of Calibration						
ł	Turning Sequence		Fit/Function	\vdash	1	Sequence						
	Wave/Twist in Tube			q . anonon	1	I Dat Oi -	CHUCHEC					

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D3575-5 CABIN FLOOR PROTECTOR (SHOWN) D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

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DQA:	.: Date:					_							™DART
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / U	PDATE	W	ork Order u	odate only	AEROSPACE
Work Orde	r:				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	
Part N	lo				Rework Scrap Use-as-is Suspected Unapproved		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite				-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Desci	ription of work order update	1	Initial	Act	ion		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													
						FA	ULT CAT	EGORY					
Landir	ng Gear Bending				General Bend		•	rogram			Outside Dim	ensions	Pressure/Forced
	Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence			BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Off-set Out of Calibration				Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong	Set-up Temperature/Cure Weld Wrong Stock Pulled Other	
ľ	Wave/Twist in Tube			Fit/Function		Out of Sequence							

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DART AEROSPACE LTD	Work Order:	126/98
		-
Description: Cabin Floor Protector	Part Number:	D3575-5
Inspection Dwg: D3575 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype	
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Drawing	Tolerance	Actual	al Accept	Reject	Method of	Comments	
Dimension	Tolerance	Dimension	Accept	nejeci	Inspection		
Ø3.00	+0.006/-0.001	3.∞7	/		V=5101-01		
3.38	+/-0.030	3, 38	/		T-JKM-06		
6.50	+/-0.030	6.50	-				
26.13	+/-0.030	26.13	7				
30.13	+/-0.030	30./3					
2.00	+/-0.030	2-00	_				
3.50	+/-0.030	3.50	1				
14.25	+/-0.030	14.25	_				
25.13	+/-0.030	25.13	1				
29.38	+/-0.030	29.38	-				
30.38	+/-0.030	36.38					
31.50	+/-0.030	31.50	-				
1.00	+/-0.030	1.00					
4.38	+/-0.030	4.38					
14.50	+/-0.030	14.50	-				
16.00	+/-0.030	16.00	-				
23.13	+/-0.030	21./3					
26.88	+/-0.030	24.88	<u></u>				
27.69	+/-0.030	27.69	-				
1.00	+/-0.030	1.00	_				
3.75	+/-0.030	3.75					
9.63	+/-0.030	9.63		<u> </u>			
16.13	+/-0.030	16.13					
28.06	+/-0.030	28.06	-				
32.15	DAF/-0.030	32-15	-				
		1 - a - 13	_1			<u> </u>	

Measured by: 9-89

Date: 14 /n /c)

Audited by: DAS g

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised b		Approved
Α	08.01.16	New Issue	KJ//DD	ckt_	
	•		 -	· ()	_·· •

NCR No. Use-as-is Thermoforming Finishing Rec/Store/Packaging O Large Fab Composite Supplier Root Description of work order update Initial Action Sign &	ΔRT
Rework Skid-tube Crosstube Water Jet Engineer	ROSPACE
Rework Scrap Use-as-is Suspected Unapproved Unapproved Use-as-is Suspected Unapproved Use-as-	
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Incoposition Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved Handling Gear General Description Date Verification QC Incoposition QC Incoposition Date Verification QC Incoposition QC Incoposition Date Verification QC Incoposition QC Incoposition QC Incoposition Date Verification QC Incoposition QC Incoposition Date Verification QC Incoposition QC Incoposition Date Verification Date Verification QC Incoposition Date Verification Date Verification Date Verification Date Verification Date Verif	ering uality Other
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Incoposition Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved Handling Gear General Description Date Verification QC Incoposition QC Incoposition Date Verification QC Incoposition QC Incoposition Date Verification QC Incoposition QC Incoposition QC Incoposition Date Verification QC Incoposition QC Incoposition Date Verification QC Incoposition QC Incoposition Date Verification Date Verification QC Incoposition Date Verification Date Verification Date Verification Date Verification Date Verif	
Design Design Design Description Des	spector
FAULT CATEGORY Landing Gear General Bending Bend Folio/Program Outside Dimensions Pressure/F Centre Not Concentric BOM/Route Grain Over/Under tolerance Set-up	
Landing Gear Bending Centre Not Concentric General Folio/Program Outside Dimensions Pressure/F Grain Over/Under tolerance Set-up	
Bending Bend Folio/Program Outside Dimensions Pressure/F Centre Not Concentric BOM/Route Grain Over/Under tolerance Set-up	
Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Part Lost/Missing Weld Cuffs Contamination Instructions Incomplete/Unclear Part Moved Wrong Sto Crushing Countersink Misaligned/off center Positioned Wrong Heat Treat Cut Too Short Mislabeled Power Loss/Surge Other Inspection Strip in Tube Drawing Misread Marks/Chatter Drill Holes Off-set	ure/Cure
Turning Sequence Finish Out of Calibration Wave/Twist in Tube Fit/Function Out of Sequence	

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